LET	ALTERATION	DATE	BY
Q	CAC NU 45-50 NUT ST. STEEL (MIL [illegible]) WAS AC366 D1032. ADDED NOTE "ELASTIC ... CAC NU 45-50". WT. CHG. NEG.	[illegible]	[illegible]
R	DIM 2 1/8 WAS 1 3/4 ; 2 1/8 WAS 2. NO WT. CHG.	[illegible]	[illegible]
S	FROM SEC. A-A REMOVED CAC NU [illegible] (SEE NOTE) & ADDED CVAC NU391-20 (6191A-102) TINNERMAN PRODUCTS INC CLEVELAND, OHIO. Q7103-A1. #10 (.193) HOLES IN -24 SUB ASS'Y WAS #10 (.1695) HOLES IN -24 SUB ASS'Y. IN [illegible] REMOVED AC366 DF1032 & ADDED CVAC NU391-20 & Q7103-A1. WT. CHG. NEG.	[illegible]	[illegible]

LET	ALTERATION	DATE	BY
	& AC372 D1032 (12) TO -16 L & R SUB-ASSYS. WT CHG NEG.	[illegible]	[illegible]
H	TO NOTE AN442D4 APP 3/4 SP ADDED "OR SPOTWELD". WT CHG NEG.	[illegible]	[illegible]
J	REMOVED DIMS 6 & 6 7/16 & ADDED 6 11/16 & 6 7/8 IN SEC A-A. REMOVED DIMS 1 & 9 ADDED 3/32 & 8 11/16. CHGD -26 L/R TO -27 L/R -28 L/R -29 L/R & -30 L/R. CHGD METHOD OF DIMENSIONING #10 HOLES IN VIEW B-B. IN AUX VIEW REMOVED DIMS 1/4 & ADDED 1/2. ADDED SECS. E-E & F-F. WT CHG NEG.	[illegible]	[illegible]
K	ADDED SLOT FOR THERMOCOUPLE IN -22 L/R. WT CHG NEG.	[illegible]	
L	-10L REPLACED BY -32L & -11L BY -34L. CHGD SECT A-A TO SHOW FLANGE ON -22L & -23L INSTEAD OF ON -20 & 21 DIM. 1 1/2 WAS 9/32 & 3 WAS 3 1/2 (2 PLACES). NOTE "#10 (.1695) -24 SUB-ASSY..." WAS FOR -16 & -17. SECT. E-E - DIM. 3/4 WAS 1/2. WT. CHG. NEG.	[illegible]	[illegible]
M	SECT. D-D & AT ZONE E-2 DIM 1 1/2 WAS 1. NO WT. CHG.	7/7/43	[illegible]
N	IN SEC DD NOTE "#28 (.1405) - - - PLACES" WAS "#10 (.1695) DIA. HOLES 4 PLACES." NO WT. CHG.	7/7/43	[illegible]
P	ZONE B-5 DIM 5/8 WAS 1/2, ADDED 5/8 DIM. WT CHG. NEG.	9/7/43	[illegible]

LET	ALTERATION	DATE	BY
B	REDESIGNED & REDRAWN.	[illegible]	[illegible]
C	ON FACE (INBOARD) REQ/PLANE [illegible] -6L & R TO -16L & R -7L & R TO -17L & R -8 TO -18 & -9 TO -19. NO WT. CHG.	[illegible]	[illegible]
D	REMOVED -13L & R & -14L & R ADDED -20L & R -21L & R -22L & R & -23L & R. CHGD. SEAMS FROM 2 TO 4 & ADDED SPOT WELD & RIVET NOTES. REMOVED DIMS 3 1/32 & 1/2 & ADDED 5/16 & 11/16 DIMS. WT CHG NEG.	[illegible]	[illegible]
E	IN [illegible] REMOVED AC366 DF1032 (12) FROM -16L & R & -17L & R SUB-ASSYS. ADDED -24 SUB-ASSY COMPOSED OF -18, AC366 DF1032 (12) & AN425D3 ON FACE. REMOVED NUT PLATES FROM -16 & -17 SUB-ASSYS & ADDED THEM TO -24 WITH LOCATING DIMS. IN DET. "C" REMOVED NOTE "SLOTS (3/16 x 9/32)" & ADDED NOTE "SLOT 11 PLACES - ETC." ADDED VIEW D-D. WT. CHG. NEG.	[illegible]	[illegible]
F	REMOVED -19L & R & ADDED -26L & R. CHGD DIM 1/4 TO 1/2 ON 3 SIDES IN VIEW B-B. WT CHG NEG	3/15/43	[illegible]
G	CHGD -18 TO -25 & CLAMP ATTACHMENT TO LAP SEAM. ADDED AC366 DF1032 (1) TO -24 SUB-ASSY & IN DET. "C" CHGD SLOTS (11) TO (12) IN VIEW D-D CHGD. 3/16 R TO 5/32 R. REMOVED AN425D3 & ADDED Q5106 D10-8 (12)		

E.O. B25051

E.O. B10002

E.O. B20345

E.O. B21180

SECTION F-F
SCALE 6"-1'0"

-10L (REF)

VIEW B-B
SCALE 6"-1'0"

-28L -27L -29L -30L

#10 (.1935) HOLES (12)

DETAIL C
SCALE 12"-1'0"

-10 (REF)

-25 (REF)

SLOT 12 PLACES IN UPPER DUCT
12 PLACES IN LOWER DUCT TO MATCH
ANCHOR NUTS ON -25

℄ NACELLE (REF)

#10 (.1935) HOLES (12)
CAC NU 45-50 (SEE NOTE 2)
AN425D3 CSK IN -12L

REAR FACE OF ENGINE MT TERMINAL FITTING (REF)

CONTOUR TO MATCH NACELLE

AN442D4

-34L

-32L

SECTION E-E
SCALE 6"-1'0"

-34L (REF)

-32L (REF)

-17 SUB ASSY
UPPER NACELLE DUCT

-12L

-10

-25

-20L

-22L

-21L

-23L

-16L SUB-ASSY
LOWER NACELLE DUCT

SPOT WELD AT APPR. x 3/4 SPACING

1/8 R - ALL CORNERS

SEE VIEW BB

AN 442-D4
APPROX 3/4 SPACING
OR SPOTWELD

℄ NACELLE (REF)

Q5106 D10-8 (12)
AC372 D10 32 (12)

DUCT MAY BE TRIMMED ON
INSTALLATION TO ALLOW FOR
VARIATION IN WING STRUCTURE.

-24 SUB ASSY

-25 (REF)

-22 (REF)

-23 (REF)

#10 (.193) HOLES IN -24 SUB-ASS'Y
CVAC NU391-20 (6191A-102)
TINNERMAN PRODUCTS INC.
CLEVELAND, OHIO
Q7103-A1
AN425 D3 RIVET THRU -25
(SEE DETAIL C)
12 PLACES ON -25

SECTION A-A
SCALE 6"-1'0"

#28 (.1405) DIA HOLES
4 PLACES

VIEW D-D

DASH NO	WT.
-16 L & R SUB-ASSY	2.6 EA.
-17 L & R SUB-ASSY	1.09 EA.
-18	.31
-24 SUB-ASSY	.00

NOTE:
1. C.A.C. FAB 13 MAY BE PURCHASED U.S. RUBBER CORP. LOS ANGELES, CALIF. VENDOR'S NO. STYLE 0-52 OR 50
2. ELASTIC STOP NUT PLATE #22 HA1-02 CAC NU 45-50 MAY BE USED AS ALTERNATE FOR 70 HA1-02 CAC NU 45-50. (PURCHASED FROM ELASTIC STOP NUT CORP., UNION, N. J.)

FLUSH: 2 AFTER SPOTWELDING 1 COAT ZINC CHROMATE PRIMER SPEC P27E ON COAT HEAT RESISTING ALUMINUM VARNISH.

PART No.	STOCK	MATERIAL	SPEC	REQ	ZONE
CVAC NU391-20 (TINNERMAN #6191 A-102)				12	
Q7103-A1				12	
AN425D3				12	E2
-25	.064 x 3/4 x 30	ALCLAD	QQA362 II	1	D4
-24	SUB-ASS'Y				E1
AN442D4					
AN425D3					C3
CAC NU 45-50 NUT 79HA1-02 (SEE NOTE 2)				12	C3
-12R	Y2A23T x 25			1	C5
-34R	.032 x 14 x 23	ALCLAD	QQA362 II	1	C2
-32R	.032 x 14 x 17	ALCLAD	QQA362 II	1	C-2
-17R	SUB-ASS'Y				C-5
AN442D4					
AN425D3					C-3
CAC NU 45-50 NUT 79HA1-02 (SEE NOTE 2)				12	C-3
-12L	Y2A23T x 25			1	C-5
-34L	.032 x 14 x 23	ALCLAD	QQA362 II	1	C-2
-32L	.032 x 14 x 17	ALCLAD	QQA362 II	1	C-2
-17L	SUB ASS'Y				C-5
AC372 D10 32				12	E5
Q5106 D10-8				12	E5
AN442D4					
-30R	Y6A21T x 6 1/2			1	B4
-29R	Y2A43T x 5 5/8			1	B5
-28R	Y2A43T x 6 1/2			1	A4
-27R	Y2A43T x 5 1/2			1	B4
-23R	.032 x 16 x 30	ALCLAD	QQA362 II	1	E5
-22R	.032 x 15 x 30	ALCLAD	QQA362 II	1	E4
-21R	.032 x 10 x 30	ALCLAD	QQA362 II	1	E4
-20R	.032 x 10 x 30	ALCLAD	QQA362 II	1	D-4
-16R	SUB-ASS'Y				E-5
AN442D4					
AC372 D10 32				12	
Q5106 D10-8				12	
-30L	Y6A21T x 6 1/2			1	B4
-29L	Y2A43T x 5 5/8			1	B5
-28L	Y2A43T x 6 1/2			1	A4
-27L	Y2A43T x 5 1/2			1	B4
-23L	.032 x 16 x 30			1	E5
-22L	.032 x 15 x 30			1	E4
-21L	.032 x 10 x 30			1	E4
-20L	.032 x 10 x 30			1	D4
-16L	SUB ASS'Y				E5
-24	SUB-ASS'Y				
-18	1/16 x 3 1/8 x 30	NEOPRENE	FAB 13		D-5
-17R	SUB-ASS'Y				
-17L	SUB-ASS'Y				
-16R	SUB-ASS'Y				
-16L	SUB-ASS'Y				

PARTS LIST PER ASSY.

DASH No.	MODEL	PART ASSY	REQ
-24	PBY-5A	28F7011	4
-18	PBY-5A	28F7011	2
-17R	PBY-5A	28F7011	1
-17L	PBY-5A	28F7011	1
-16R	PBY-5A	28F7011	1
-16L	PBY-5A	28F7011	1
-24	PBY-5	28F7011	4
-18	PBY-5	28F7011	2
-17R	PBY-5	28F7011	1
-17L	PBY-5	28F7011	1
-16R	PBY-5	28F7011	1
-16L	PBY-5	28F7011	1

MCR 178-3

MCR #23-10

REQUIREMENTS PER AIRPLANE

REPLACES 28F6922 OF 9-8-42 — NOTED

SCALE 6"=1'0" & NOTED

STAMP PART NUMBER WHERE SHOWN

APPROVED FOR TOOLING BY
Humphreys

NAVY NONE — NOTED
HEAT TREAT — FINISH

NAME: DUCT ASS'Y ANTI-ICING-CELL

CONSOLIDATED AIRCRAFT CORP. SAN DIEGO, CALIF.

J — 28F6922

28F6922 R